



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-B-03

Job Sheet 194559



Part No: RBE350A94-3700-B-03

Job Qty: 30 pcs

Part Name: Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 6/14/19 *MLJ 36*

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-B Rev. 6 IPP Rev. A 18.08.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
120	SL-2500Y - 1	30 pcs	6/14/19	6/14/19	0.00	5.00	SL-2500Y - 1	<i>SL 19-5-14</i>
130	QC 2	30 pcs	6/14/19	6/14/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	<i>SL</i>
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S181129



Part: RBE350A94-3700-B-03

Job No: 194559

Serial No/Batch: S181129

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 05/14/19

140 QC 8	30 pcs	6/14/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	m/19/05/16
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
170 Outsource - 12 - Black Oxide	30 pcs	6/14/19		GRO002-VC	10
180 Packaging 2-1 - Receive - B4B	30 pcs	6/14/19	0.00 0.00	Packaging 2 - 1 - B4B	MAY 29 2019
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	

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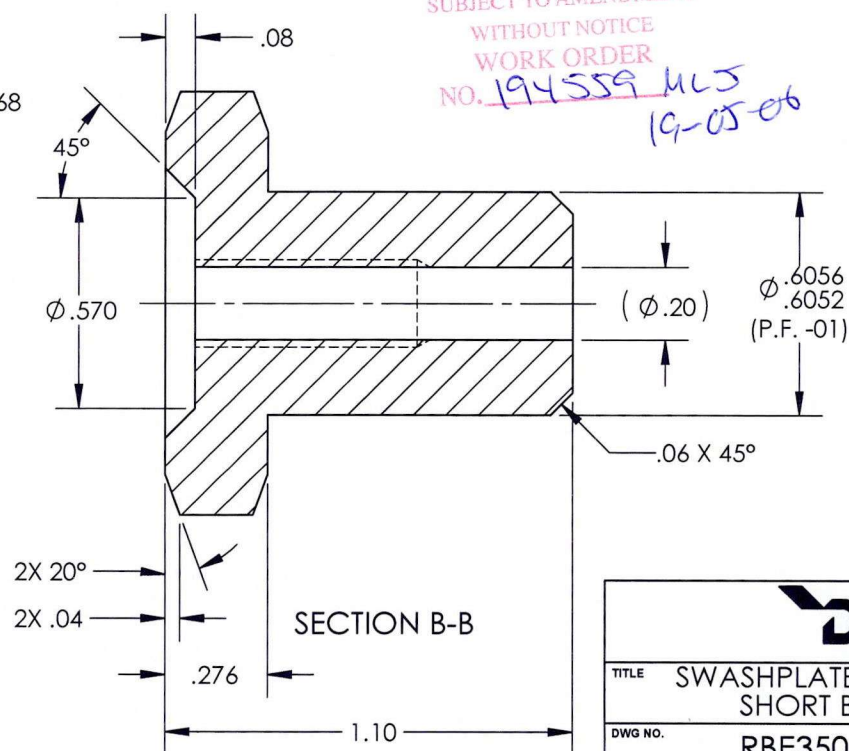
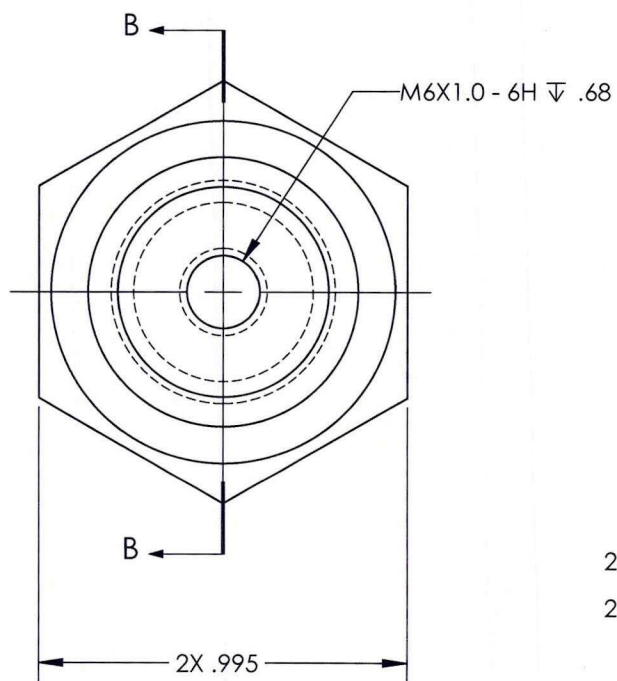
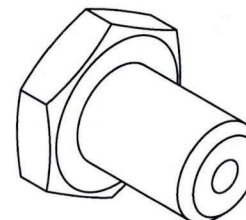
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 6	30 pcs	6/14/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	MAY 29 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
200 Packaging 3-1 - Stock - B4B	30 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC GA + BD
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	30 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89 MAY 30 2019
Part Op 120 - 1-Machine as per folio FC727 FOLIO REV: <u>AA</u> DWG REV: <u>6</u> 2-Deburr Descriptions: 130 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB) 140 - QC8 Machining-4 (QC8- Inspect parts - second check) 170 - Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required 180 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs) 190 - QC6 (QC6- All purchased or subcontracted products) 200 - Packaging3-1 (Identify as per dwg & Stock Location: _____) 210 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-1144-H1.000	AISI 1144 Stressproof Steel Hex Bar 1.000"	3.2400 ft (.108 ea)	120-SL-2500Y - 1	5179663	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-SL-2500Y - 1	MT-1144-H1.000	3	1	0
Part Specifications				
Specifications could not be found.				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		-03 CH'D DIM WAS Ø.570 ↕ .079 IS Ø.570, ADDED DIM Ø.586 P.F. -01, (Ø.20).	5/23/2014	DPD	RJC
6	16-0151	-03 CH'D DIM WAS Ø.586 P.F. -01 IS Ø.6056/.6052 (P.F. -01), ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D.	2/24/2017	RJC	SM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194559 MLS
19-05-06



(-03)

CAP

			
TITLE SWASHPLATE IMMOBILIZING TOOL SHORT BRACE ASSEMBLY			
DWG NO. RBE350A94-3700-B-03			REV 6
MAT'L SP HEX		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 SURFACES = 125/√	
FINISH BLACK OXIDE			
SPEC QMSI-6.2.2, B.O. REV D		1. BREAK ALL SHARP EDGES .015 X 45° OR .015R	
DRAWN BY:	CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED:	DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPPS APPR:	ANDERSON	USED ON MODEL	
QA APPR:	LINDSAY	EUROCOPTER AS350/355	
APPROVED:	GILBERT		
SCALE 2:1	DATE 8/21/2012	SHEET 4 OF 5	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
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Tel (613) 632-5200

PURCHASE ORDER

POHB043490



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043490

PO Date: 5/17/19

Due Date: 5/24/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-05-20

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193406	RBE350A94-3700-A-03	Top -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	5/24/19	41 pcs	0 pcs	41 pcs	\$1.89/pcs	\$77.49
							41 X MAY 29 2019				
2	194559	RBE350A94-3700-B-03	Cap Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	5/24/19	30 pcs	0 pcs	30 pcs	\$1.52/pcs	\$45.60
							30 X MAY 29 2019				
3	192578	RBT18603-7	Foot -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	5/24/19	10 pcs	0 pcs	10 pcs	\$0.55/pcs	\$5.50
							10 X MAY 29 2019				



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PURCHASE ORDER

POHB043490



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	193355	RBE350A93-3303-02-7	Stud Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed X50	-	5/24/19	50 pcs	0 pcs	50 pcs	\$1.79/pcs	\$89.50
Grand Total:											\$218.09

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/21/19 2:26 PM Dart.Guerin.Kimberley


Certificat de Conformité / Certificate of Compliance

(019358-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip
019358- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
27-May-2019		SVETLANA DORZHIYEVA		POHB043490 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3700-A-03 ✓ Rev.	RBE350A94-3700-A-03 01 -BLACK OXIDE ON MIL-DTL-13924C CLASS 1	BLACK-OXIDE CH	41	41 ✓	0	0	0
2	RBE350A94-3700-B-03 ✓ Rev.	RBE350A94-3700-B-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	30	30 ✓	0	0	0
3	RBT18603-7 ✓ Rev.	RBT18603-7 01 -BLACK OXIDE ON MIL-DTL-13924C CLASS 1	BLACK-OXIDE CH	10	10 ✓	0	0	0
4	RBE350A93-3303-02-7 ✓ Rev.	RBE350A93-3303-02-7 BLACK OXIDE FINISH, MIL-C-13924C , CLASS 1	BLACK-OXIDE CH	50	50 ✓	0	0	0

RECEIVED
MAY 28 2019
DART AEROSPACE LTD.

RECEIVED

MAY 28 2019

DART AEROSPACE LTD.
Notes Additionnelles / Additional Notes**Epaisseur réelle
Actual Thickness**
**Inspecteur Qualité
Quality Inspector**
**Réçu par
Received By**

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.